

# Work Order ID 56257

Wednesday, February 17, 2010 11:04:30 AM

Page 1

Item ID: D2916-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Cable Guard, 212 Skidtube

Start Date: 2/18/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2916

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2916 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

10-2-17

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-2-17

120

HAAS CNC VERTICAL MACHINING #1

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

BATCH: 113166 ☐ 1- Mill as per Folio FA2916-1 Rev:  
AB & Dwg D2916 Rev: B ☐ 2-Deburr per dwg D2916

10/62/23

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56257**

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

CML 10/02/23

6 0

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

MTC 10/02/23

6 0

Quality Control

150

Identify as per dwg &amp; Stock Location: 207

0.00



Packaging

Memo

0.00

PC 10/3/07 6

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Item Name: Cable Guard, 212 Skidtube

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Start Date: 2/18/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03  
CY 03/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 17, 2010 11:04:29 AM

Page 1

Work Order ID: 56257



Parent Item: D2916-1



Parent Item Name: Cable Guard, 212 Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev:A New Issue 06-06-19 JLM  
IPP Rev:B Now water jet 06-07-14 EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	457.9905	2.0000	3.		
UHMW 1" Black												

10-2-17

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

426.2428

112186

122.0164

113166

28.6264

113903

275.6

113166

Main Warehouse

ST

31.7477

111354

31.7477

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>SL257</i>
<b>Description:</b> Cable Guard		<b>Part Number:</b> D2916-1
<b>Inspection Dwg:</b> D2916	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

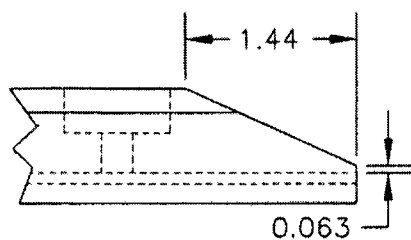
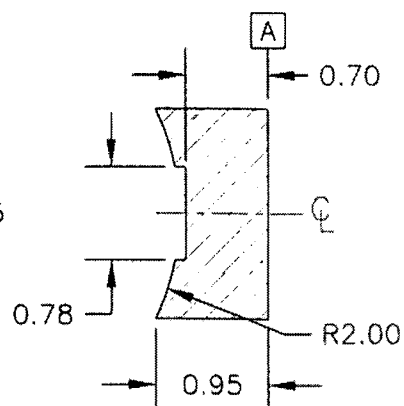
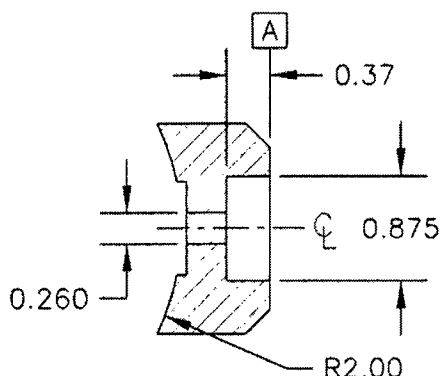
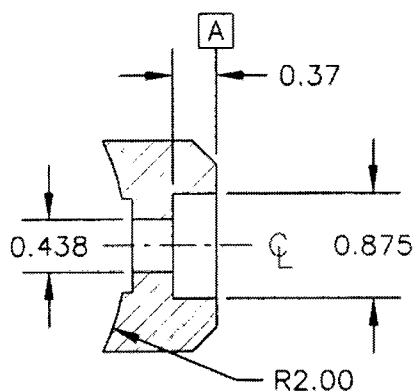
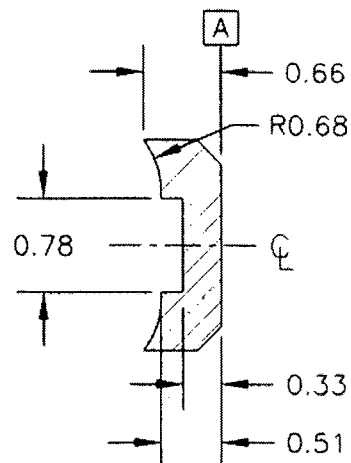
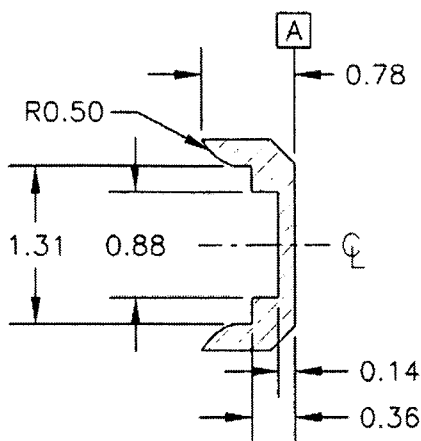
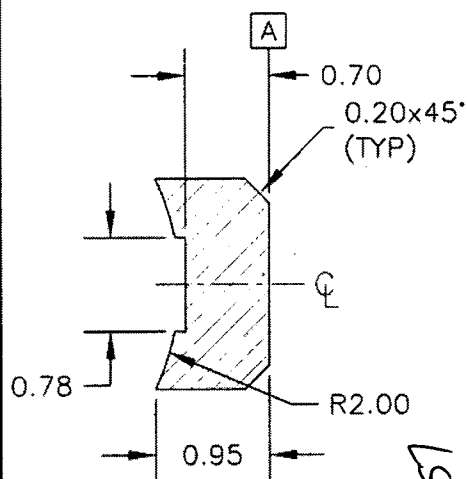
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1.75	+/-0.030	1.755	✓			
38.94	+/-0.030	38.94	✓			
35.94	+/-0.030	35.94	✓			
32.25	+/-0.030	32.250	✓			
29.00	+/-0.030	29.00	✓			
15.00	+/-0.030	15.00	✓			
11.31	+/-0.030	11.310	✓			
3.19	+/-0.030	3.19	✓			
2.000	+/-0.010	2.010	✓			
21.125	+/-0.010	21.135	✓			
37.938	+/-0.010	37.948	✓			
Ø0.438	+0.005/-0.000	.438	✓			
25.00	+/-0.030	25.00	✓			
24.00	+/-0.030	24.00	✓			
16.50	+/-0.030	16.500	✓			
15.01	+/-0.030	15.01	✓			
3.25	+/-0.030	3.270	✓			
2.33	+/-0.030	2.350	✓			
A-A	0.78	.780	✓			
	0.70	.693	✓			
B-B	0.140	.145	✓			
	0.360	.360	✓			
	0.88	.862	✓			
C-C	1.31	1.306	✓			
	0.78	.752	✓			
	0.33	.327	✓			
D-D	0.37	.372	✓			
	Ø0.438	.438	✓			
	Ø0.875	.872	✓			
E-E	Ø0.260	.260	✓			
	0.37	.371	✓			
	Ø0.875	.871	✓			
J-J	1.44	1.44	✓			
	0.063	.070	✓			

<b>Measured by:</b> <i>LS</i>	<b>Audited by:</b> <i>MNE</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/02/22	<b>Date:</b> 10/02/23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	P/O D205-665-015	KJ/RF <i>JS</i>

**DART**

DESIGN #	DRAWN BY P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	



DETAIL J  
(SCALE 2:3)

RELEASED  
00.02.25 DS

# Dart Aerospace Ltd

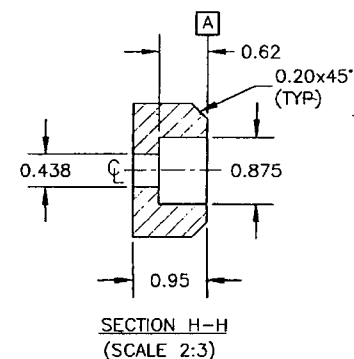
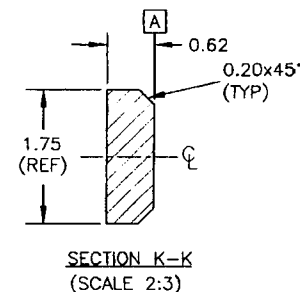
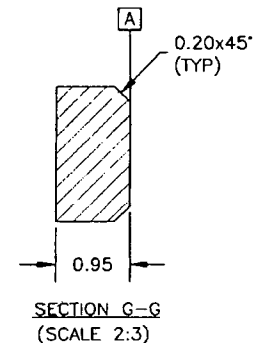
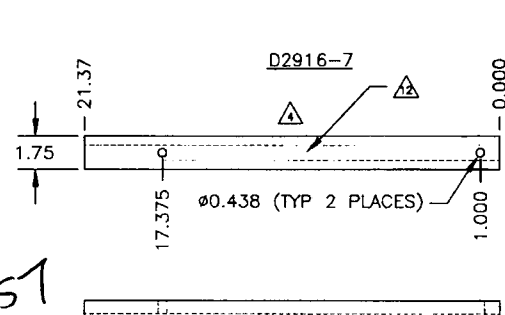
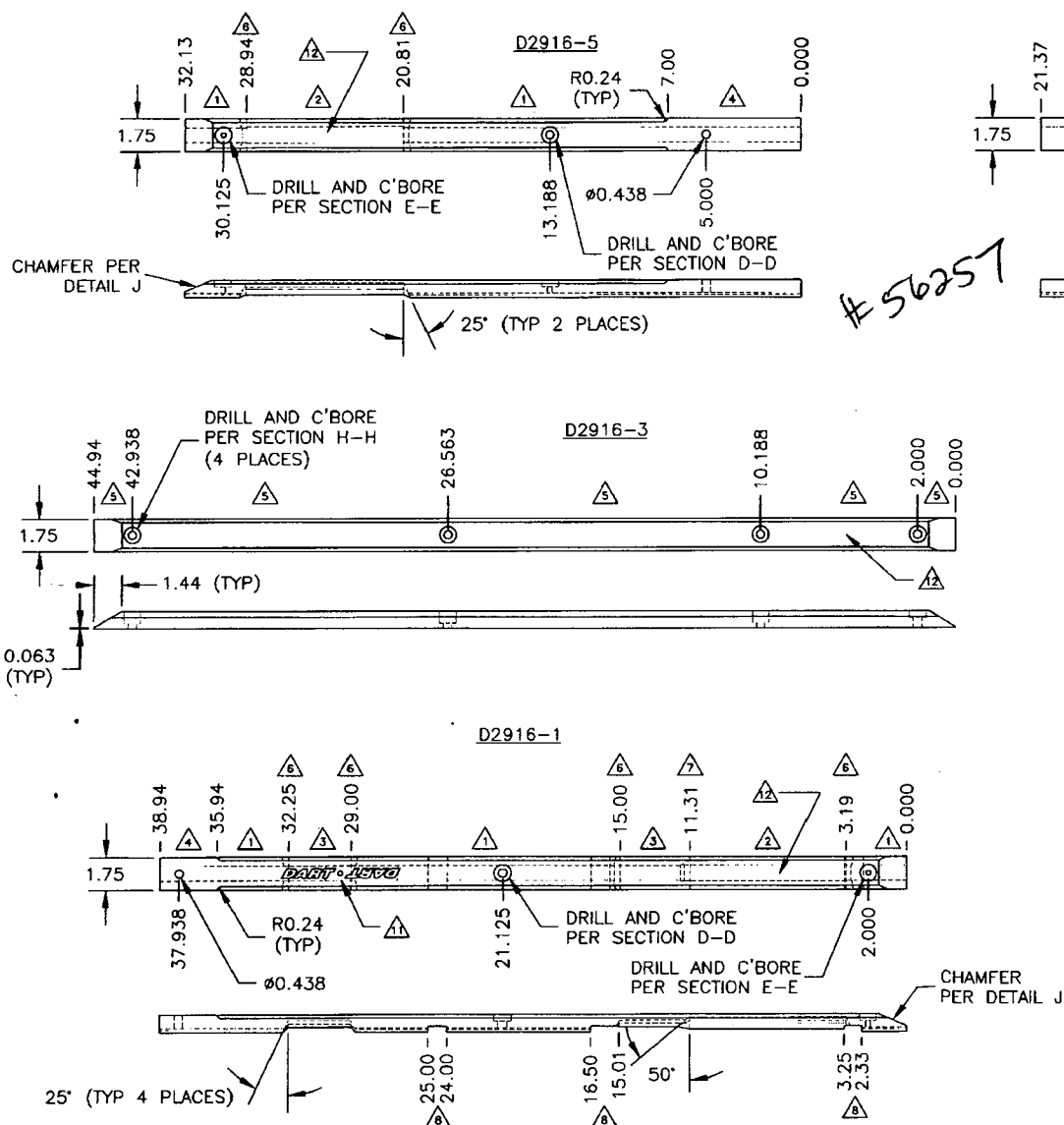
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**NOTE:** Date & initial all entries



# NOTES:

- 1) MACHINE CONSTANT SECTION A-A
- 2) MACHINE CONSTANT SECTION B-B
- 3) MACHINE CONSTANT SECTION C-C
- 4) MACHINE CONSTANT SECTION F-F
- 5) MACHINE CONSTANT SECTION G-G
- 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
- 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
- 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
- 13) ALL HOLES DRILLED ON CENTERLINES
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 15) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
100-02 25 DS

DESIGN #	DRAWN BY	<b>DART</b> DART AEROSPACE LTD WILKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2916	REV. B SHEET 2 OF 2
DATE		TITLE CABLE GUARD	SCALE 1:6
00.02.24			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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